













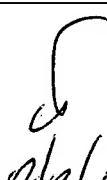





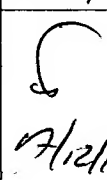
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 36226		
Estimate Number	: 12704		
P.O. Number	: N/A	Part Number	: D35501
This Issue	: 12/10/2007 S.O. No. : N/A	Drawing Number	: D3550 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: MA	Drawing Revision	: B
Previous Run	: 32450	Material	: N/A
Written By	: <u> </u>	Due Date	: 12/17/2007
Checked & Approved By	: <u> </u>	Qty:	20
Comment	: Est. A 07.02.05 New issue EC	Um:	Each
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W049	304 RD Tube .500 x .049W	
			
Comment: Qty.: 1.7850 f(s)/Unit Total : -47.8500 f(s) 42.033			
304 RD Tube .500 x .049W			
304/316 Seamless tubing, 1/2" OD x .049 Wall			
Batch M1004862 SB 07/12/10			
2.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE			
1-Form per Dwg D3550 N18012			
SAP 07-12-18 19			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1			
Deburr if necessary.			
SAP 07-12-18 19			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
5 A/12/18 X15			
5.0	POWDER COATING	POWDER COATING	
			
Comment: POWDER COATING			
Powder Coat White Gloss (Ref. 4.3.5.2) as per QSI 005 4.3			
FL 07/12/19 5			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/12/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-18	2.0	One part scrap, didn't form correctly P.C. no jig for forming the flat END. that error		Scrap, destroy No replace made jig for forming flat END ON part	SAD 07-12-18 07/12/18			
07/12/18	2.0	Four (4) parts have the hole fl center by 0.000" to 0.000". P.C. Hammer/setup error		Scrap the four (4) parts. No replace	SAD 07-12-18 07/12/18			
				Total amount scrap is 45 on this work				

NOTE: Date & initial all entries

Date: Monday, 12/10/2007 12:04:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 36226

Part Number: D35501

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-19

(X15)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 271

W

AS 07/12/19

(15)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/20

Job Completion



run 2007/12/20

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

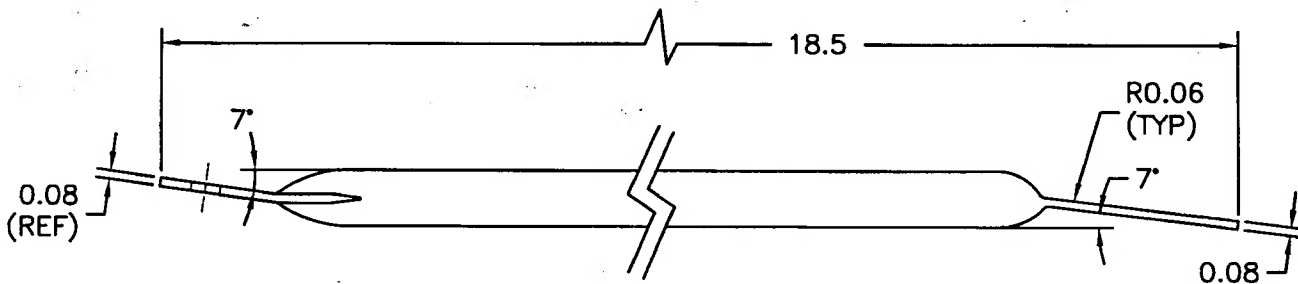
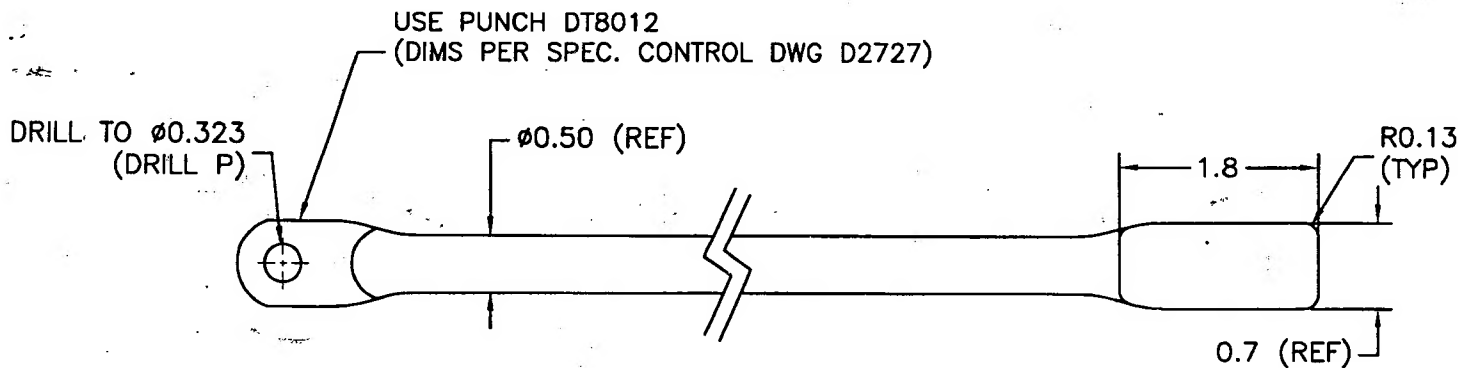
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B
CE	CE	DRAWING NO.	D3550	SHEET 1 OF 1
CHECKED PH	APPROVED H	TITLE	STRUT	SCALE NTS
DATE 07.02.13				
A	06.10.24	NEW ISSUE		
B	07.02.13	18.5 WAS 20.13; 1.8 WAS 1.5		



D3550-1 STRUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36226

NOTES:

- 1) MATERIAL: 304/316 SS SEAMLESS ROUND TUBE 0.500 OD X 0.049 WALL
(REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3550-1 USING FINE POINT PERMANENT INK MARKER

RELEASED
07.02.13